



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5090-3
Job Sheet 183611



DAS
21
3-09

Part No: D5090-3

Job Qty: 20 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 10/3/18

Created By: Shannon Hadley

Type: SOLD

Description:

Note: D5090 REV.D SHEETS 3,4,5 IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	20 pcs		10/3/18	0.00	1.99	Waterjet 1		SC 18/07/18 DAS
120	QC	20 pcs		10/3/18	0.00	0.00	QC8		SEP 26 2018 68
130	Brake NC	20 pcs		10/3/18	0.00	1.03	Brake NC 2		SEP 26 2018 68
140	QC	20 pcs		10/3/18	0.00	0.00	QC5		OCT 03 2018 68
150	HandFinish	20 pcs		10/3/18	0.00	1.19	HandFinish1		D.R 18/10/18 38
160	QC	20 pcs		10/3/18	0.00	0.00	QC7-4		
190	Packaging	20 pcs		10/3/18	0.00	0.00	Packaging3-2	54226	OCT 03 2018
200	QC21-SA	20 Ea		10/3/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1-Cut as per Dwg Prog Rev: D 2-Debur as required

DAS
21
3-09

OCT 03 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	14 sf (.7 ea)	100-Waterjet	5099479

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.040	14	194	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.129Inches + 0.005 - 0.001	0.134 0.128		Diameter
2	Bracket	0.840Inches ± 0.030	0.870 0.810		
3	Bracket	0.520Inches ± 0.030	0.550 0.490		
4	Bracket	0.375Inches ± 0.010	0.385 0.365		
5	Bracket	0.875Inches ± 0.010	0.885 0.865		
6	Bracket	0.790Inches ± 0.030	0.820 0.760		
7	Bracket	0.950Inches ± 0.030	0.980 0.920		
8	Bracket	4.620Inches ± 0.030	4.650 4.590		
9	Bracket	5.580Inches ± 0.030	5.610 5.550		
10	Bracket	17.540Inches ± 0.030	17.570 17.510		
11	Bracket	0.040Inches ± 0.030	0.070 0.010		

Part 021/15 143 Dart.Hadley.Shannon

DART
 AEROSPACE
 Container No: S113677
 Part: D5090-3
 Job No: 183611
 Serial No/Batch: S113677
 Revision: D
 Inspector:
 Exp Date:
 Instructions: Various STC's
 Date: 09/26/18
 HAWKSBURY, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartero.com
 WWW.DARTEROSPACE.COM



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Tel (613) 632-5200
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D5090-3

Job Sheet 183296



Part No: D5090-3

Job Qty: 20 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/15/18

Job Tracking No:

Due Date: 10/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5090 REV.D SHEETS 3,4,5 IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		10/3/18	0.00	0.00	Start Up Waterjet		
100	Waterjet	20 pcs		10/3/18	0.00	1.99	Waterjet1		
120	QC	20 pcs		10/3/18	0.00	0.00	QC8		
130	Brake NC	20 pcs		10/3/18	0.00	1.03	Brake NC 2		
140	QC	20 pcs		10/3/18	0.00	0.00	QC5		
150	HandFinish	20 pcs		10/3/18	0.00	1.19	HandFinish1		
160	QC	20 pcs		10/3/18	0.00	0.00	QC7-4		
190	Packaging	20 pcs		10/3/18	0.00	0.00	Packaging3-2		
200	QC21-SA	20 Ea		10/3/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1-Cut as per Dwg Prog Rev: _____ 2-Deburr as required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	14 sf (.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.040	14	194	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.129Inches + 0.005 - 0.001	0.134 0.128	0.130	Diameter
2	Bracket	0.840Inches ± 0.030	0.870 0.810	0.844	
3	Bracket	0.520Inches ± 0.030	0.550 0.490	0.525	
4	Bracket	0.375Inches ± 0.010	0.385 0.365	0.379	
5	Bracket	0.875Inches ± 0.010	0.885 0.865	0.880	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Plex 9/17/18 7:46 AM Dart.lajeunesse.marie

6	Bracket	0.790Inches ± 0.030	0.820 0.760	0.792
7	Bracket	0.950Inches ± 0.030	0.980 0.920	0.956
8	Bracket	4.620Inches ± 0.030	4.650 4.590	4.634
9	Bracket	5.580Inches ± 0.030	5.610 5.550	5.587
10	Bracket	17.540Inches ± 0.030	17.570 17.510	17.540
11	Bracket	0.040Inches ± 0.030	0.070 0.010	0.040

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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